

Work Order ID 66184



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Monday, February 07, 2011 11:51:21 AM

Item ID: D2055	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Clamp					
Start Date: 2/8/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 2/22/2011	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-02-07</u>	Tooling:	Date:	Run	Start	
	QC: <u></u>	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2055	Rev C1								

100	Hardinge CNC LATHE SMALL	0.00				10	φ		
Doosan	Memo	0.00							
Doosan Lathe	Machine as per Folio FA203 deburr all sharp edges as per dwg		11/04/20						

110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	φ		
QC	Memo	0.00							
Quality Control			11/04/20						

120	QC8- Inspect parts - second check	0.00				10			
QC	Memo	0.00							
Quality Control			11/04/21						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2055

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 2/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>10</u>		<u>BL 11-4-25</u>	
160 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <u>M 11/5/28.</u> Memo START TIME: <u>7:25</u> OVEN TEMPERATURE: <u>220°</u> FINISH TIME: <u>7:55</u>	0.00 0.00				<u>10</u>		<u>BL 11-4-26.</u>	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>10</u>	<u>φ</u>	<u>BL 11/4/26</u>	

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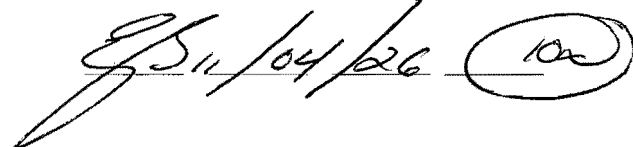

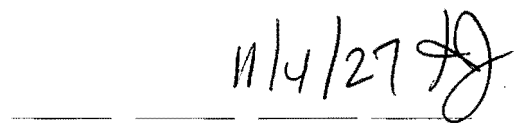
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Revision ID: Stop 
Item Name: Clamp
Start Date: 2/8/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 2/22/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>G-A</u> Memo	0.00 0.00							<u>11/04/26</u> 
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/4/27</u>  MF 11-04-26

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Picklist Print

Page 1

Monday, February 07, 2011 11:51:18 AM

Work Order ID: 66184



Parent Item: D2055



Parent Item Name: Clamp

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C 02.03.07 Now turned in house NG IPP REV:D NOW ON
DOOSAN 10-02-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 ROUND BAR 1.00"		Purchased	No			120	f	27.6140	0.1042	1.096842			



143123

LocationLoc QtyLoc Code

MAT

25.434

115609

1.434

~~116406~~

24

MAT013

2.18

108876

1.88

113457

0.3

754

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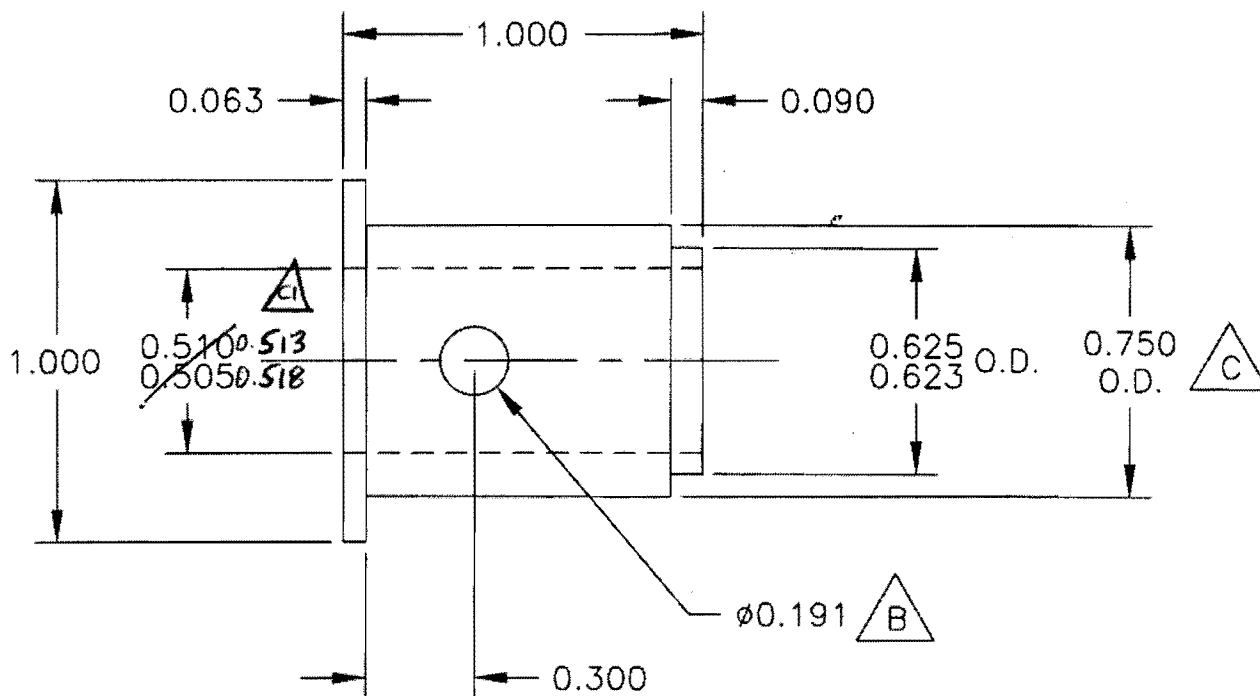
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DESIGN	JB	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	MT	DRAWING NO. D2055
				REV. C SHEET 1 OF 1
DATE	98.12.10	TITLE	CLAMP	SCALE 2:1
A	92.03.13	NEW ISSUE		
B	98.10.15	0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH		
C	98.12.10	ADDED 0.750 O.D. DIMENSION		
CI	CP	01.06.05	MODIFY HOLE SIZE, ADD P/C OPTION	

RELEASED
98.12.10 KE



#66184



ACID ETCH & ALODINE PER
DART QSI DQS 4.1
POWDER COAT BLACK SAMITEK (4.3.5.7)
PER DART QSI DQS 4.3

MATERIAL: 6061-T6 ROD (QQ-A-225/8)
FINISH: BLACK ANODIZE OR
BREAK ALL SHARP EDGES 0.015 MAX
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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